

# Work Order ID 50655

July 20, 2009 10:08:58 AM



Page 1

Item ID: D3752-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Seat Frame

Start Date: 7/22/09 Start Qty: 5.00



Cust Item ID:

Required Date: 7/31/09 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3752

Rev C

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up machine program D3752-1. Set up clamping frame as per folio

BB 09/07/20  
BB 07/07/22

110

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

BB 09/07/20 X

M109 455 XY

M111710 XI

120

0.00



THERMOFORMING MACHINE

Thermoform

Memo


0.00

Thermoforming Machine

Thermoform as per Dwg. D3752 and Folio 1 Dwg. Rev. C Folio

Rev. B

Folio

06 09/07/23 

# Work Order ID 50655

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Page 2

Item ID: D3752-1  
Revision ID: C  
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Accept

Setup Start

Stop

Start Date: 7/22/09 Start Qty: 5.00

Required Date: 7/31/09 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Dr. 09/07/23

X5

1

PK

Memo

0.00

140



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

0.00

Dr. 09/07/24

X5

Memo

0.00

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Dr. 09/07/24

X5




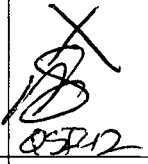
Memo

0.00

1) Check dimensions to ensure conformity to drawing tolerances.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3752-1 PAR #: N/A Fault Category: Thermobonding NCR: Yes No DQA: 1A Date: 09.07.28  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 09.08.17

NCR: <u>50655</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/27	* 130	one part <del>scrap</del> scrap @ thermoforming RL mat burned has this on one		Scrap and Destroy and Replace at <u>M109455</u> qty 11	Wh 9/9/27	S 9/10/27		S 9/19/27
		side - Program		Fix Program to prevent this from happening	Wh 9/10/27	S 9/10/27		S 9/14/27

NOTE: Date & initial all entries

# Work Order ID 50655

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Item ID: D3752-1

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Start Date: 7/22/09 Start Qty: 5.00

Required Date: 7/31/09 Req'd Qty: 5.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

8

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ 802/4/27

Ⓢ

170



Packaging

Packaging

Identify as per dwg & Stock Location: 251A

0.00

Memo

0.00

9/1/07 Ⓢ 50

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/07/28 Ⓢ

mf 09-07-28

# Picklist Print

July 20, 2009 10:08:57 AM

Page 1

Work Order ID: 50655

Parent Item: D3752-1RevC

Parent Item Name: Seat Frame

Comments:

Start Date: 7/22/09

Required Date: 7/31/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			130	sf	764.5180	53.3350			



GE PLASTICS LEXAN SHEET

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

103106

105330

109455

111710

764.518

7.8

34

0.03

702.688

Ady?

4  
1

Wt 09/07/20  
Dt 09/07/20

DART AEROSPACE LTD		Work Order:	50655
Description: Seat Frame		Part Number:	D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by:	<i>Wh</i>	Date:	09/07/23
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### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	0.044	✓			
0.035	Min	0.053	✓			
0.040	Min	0.094	✓			
0.075	Min	0.111	✓			
0.052	Min	0.77	✓			
0.021	Min	0.36	✓			
0.036	Min	0.66	✓			

Measured by:	<i>Weger</i>	Date:	09/07/23
Audited by:	<i>S</i>	Date:	08/07/23
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL <i>AK</i>	<i>fu</i>

ENSURE MATERIAL IN THIS AREA IS OPAQUE WITH A CONTINUOUS TEXTURE

OPTIONAL TOOLING HOLE.  
0.028 MIN THICKNESS  
AT THIS LOCATION

OPTIONAL TOOLING HOLE.  
0.035 MIN THICKNESS  
AT THIS LOCATION

0.040 MIN THICKNESS  
ALONG TOP EDGE

OPTIONAL TOOLING HOLE.  
0.075 MIN THICKNESS  
AT THIS LOCATION

OPTIONAL TOOLING HOLE.  
0.052 MIN THICKNESS  
AT THIS LOCATION

HEAVY HAIRCELL  
TEXTURE ON  
THIS SIDE

0.021 MIN THICKNESS  
IN THIS AREA (CORNER)

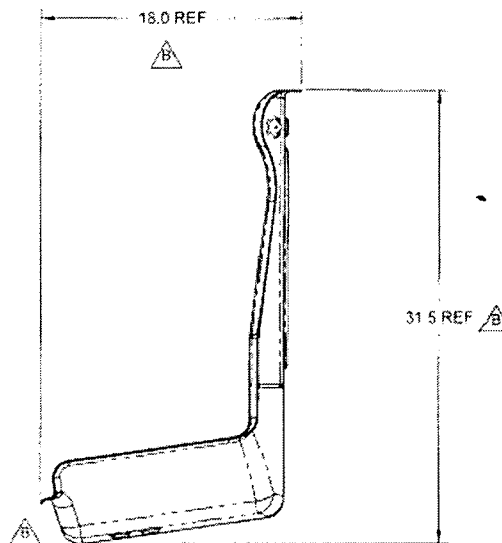
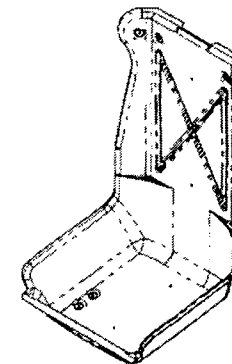
0.036 MIN THICKNESS  
ALONG BOTTOM EDGE

### D3752-1 SEAT FRAME

#### NOTES

- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY)  
(REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3752-1" & B/N "BXXXXX" USING VIBRATING STYLUS
- 7) WEIGHT: 3.0 lbs
- 8) THERMOFORM PER DT6897 AND OSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD

W/O 50655



RELEASED  
08/11/08

C	REDUCE THICKNESS: 0.040 WAS 0.050 (IN C8-1), 0.015 WAS 0.100 (C8-1), 0.052 WAS 0.040 (B8-1), 0.021 WAS 0.030 (B8-1), 0.036 WAS 0.060 (A8-1), 0.075 WAS 0.035 (D8-1), 0.035 WAS 0.050 (D8-1). SOME HOLES NOW OPTIONAL (A8-1 TO D8-1).		CP	08.10.08
	FRONT PORTION NOW SHORTER (B5-1), 18.2 WAS 19.5 (C4-1), 31.5 WAS 30.3 (B3-1). ADD 4 HOLES FOR THICKNESS MEASUREMENTS (D5-1, B8-1).		CP	08.09.09
A	NEW ISSUE		CP	08.04.25
REV	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
DRAWN	D3752		REV. C	9-4-11 C8-1
CHECKED	D3752		TITLE	SCALE
MFG. APPR.	SEAT FRAME		NTS	
APPROVED	DATE 08.10.08		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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